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K6A 1K7  
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**D4635-144**  
**Job Sheet 201711**



**Part No:** D4635-144

**Job Qty:** 1 pcs

**Part Name:** Aft Ceiling Replacement Panel Assembly, RH



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 10/9/19

**Job Tracking No:**

**Due Date:** 11/15/19

**Created By:** Marie Lajeunesse

**Type:** SOLD

**Description:**

**Note:** DWG D4635 REV.G SHEET 12 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL IPP Rev. C Dwg. Update 13/07/09 DL ver: DD IPP Rev D Dwg Update 13/12/09 DL Ipp Rev. E Dwg Update 14/01/09 DL IPP Rev. F Dwg. Update 15/01/27 DL

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation                   | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off                         |
|-------|-----------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------------------------------|
|       |                             |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |                                  |
| 110   | Small Fab - 1               | 1 pcs | 11/15/19   |          | 0.00      | 1.57    | Small Fab - 1         |           | DAS<br>NOV 04 2019               |
|       |                             |       |            |          |           |         | Small Fab - 2         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 3         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 4         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 5         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 6         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 7         |           |                                  |
|       |                             |       |            |          |           |         | Small Fab - 8         |           |                                  |
| 120   | QC 5                        | 1 pcs | 11/15/19   |          | 0.00      | 0.00    | QC 5 - 10             |           | DAS<br>NOV 08 2019<br>40<br>9-09 |
|       |                             |       |            |          |           |         | QC 5 - 12             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 17             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 18             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 19             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 22             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 24             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 3              |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 43             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 49             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 51             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 58             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 68             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 9              |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 50             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 30             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 40             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 61             |           |                                  |
|       |                             |       |            |          |           |         | QC 5 - 81             |           |                                  |
| 130   | Packaging 3-1 - Stock - B4B | 1 pcs | 11/15/19   |          | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           |                                  |
|       |                             |       |            |          |           |         | Packaging 3 - 2 - B4B |           |                                  |
|       |                             |       |            |          |           |         | Packaging 3 - 3 - B4B |           |                                  |

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10/30/2019

## [Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

|                |       |          |           |                        |  |
|----------------|-------|----------|-----------|------------------------|--|
|                |       |          |           | Packaging 3 - 4 - B4B  |  |
|                |       |          |           | Packaging 3 - 5 - B4B  |  |
|                |       |          |           | Packaging 3 - 6 - B4B  |  |
|                |       |          |           | Packaging 3 - 7 - B4B  |  |
|                |       |          |           | Packaging 3 - 8 - B4B  |  |
|                |       |          |           | Packaging 3 - 9 - B4B  |  |
|                |       |          |           | Packaging 3 - 10 - B4B |  |
|                |       |          |           | Packaging 3 - 11 - B4B |  |
|                |       |          |           | Packaging 3 - 12 - B4B |  |
|                |       |          |           | Packaging 3 - 13 - B4B |  |
|                |       |          |           | Packaging 3 - 14 - B4B |  |
|                |       |          |           | Packaging 3 - 15 - B4B |  |
|                |       |          |           | Packaging 3 - 16 - B4B |  |
|                |       |          |           | Packaging 3 - 17 - B4B |  |
|                |       |          |           | Packaging 3 - 18 - B4B |  |
|                |       |          |           | Packaging 3 - 19 - B4B |  |
|                |       |          |           | Packaging 3 - 20 - B4B |  |
|                |       |          |           | Packaging 3 - 21 - B4B |  |
|                |       |          |           | Packaging 3 - 22 - B4B |  |
|                |       |          |           | Packaging 3 - 23 - B4B |  |
|                |       |          |           | Packaging 3 - 24 - B4B |  |
|                |       |          |           | Packaging 3 - 25 - B4B |  |
|                |       |          |           | Packaging 3 - 26 - B4B |  |
|                |       |          |           | Packaging 3 - 27 - B4B |  |
|                |       |          |           | Packaging 3 - 28 - B4B |  |
|                |       |          |           | Packaging 3 - 29 - B4B |  |
|                |       |          |           | Packaging 3 - 30 - B4B |  |
|                |       |          |           | Packaging 3 - 31 - B4B |  |
|                |       |          |           | Packaging 3 - 32 - B4B |  |
|                |       |          |           | Packaging 3 - 33 - B4B |  |
|                |       |          |           | Packaging 3 - 34 - B4B |  |
|                |       |          |           | Packaging 3 - 35 - B4B |  |
|                |       |          |           | Packaging 3 - 36 - B4B |  |
| 140 QC 21 - SA | 1 pcs | 11/15/19 | 0.00 0.00 | QC 21 - SA - 21        |  |
|                |       |          |           | QC 21 - SA - 70        |  |
|                |       |          |           | QC 21 - SA - 53        |  |

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Part Op 110 - Assemble as per Dwg D4635-144 Bond foam core to inside of panel 3M Scotch Weld 1300  
 Descriptions: Batch: S 214697 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with  
 wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see  
 note 8) Batch # S 159491 Expiry Date 02/07/2020 3- Apply labels as per Dwg. and seal with 3M  
 3950 edge sealer (see note 9) Batch: m13861  
 120 - QC5- Inspect part completeness to step on W/O  
 130 - (Identify as per dwg & Stock Location: \_\_\_\_\_) identify as per dwg & Stock Location: \_\_\_\_\_  
 140 - (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

| Job BOM     |                       |              |                   |           |
|-------------|-----------------------|--------------|-------------------|-----------|
| Part / Item | Component Name        | Quantity     | Operation         | Container |
| D4635-4     | Aft Ceiling Panel, RH | 1 pcs (1 ea) | 110-Small Fab - 1 |           |
| D4669-1     | Bracket               | 1 pcs (1 ea) | 110-Small Fab - 1 |           |
| D4695-4     | Channel               | 1 pcs (1 ea) | 110-Small Fab - 1 |           |
| D4732-11    | Label                 | 1 pcs (1 ea) | 110-Small Fab - 1 |           |
| D4732-39    | Label                 | 1 pcs (1 ea) | 110-Small Fab - 1 |           |
| D4732-41    | Label                 | 1 pcs (1 ea) | 110-Small Fab - 1 |           |
| D5022-5     | Foam, Side Panel, Aft | 1 pcs (1 ea) | 110-Small Fab - 1 |           |

5130767  
 5122038  
 5158716  
 5060828  
 5060913  
 5060916  
 SPHT75

5224356  
 5224707  
 5224718

| Job Allocations                    |                |          |           |           |
|------------------------------------|----------------|----------|-----------|-----------|
| Operation                          | Component Part | Required | Inventory | Allocated |
| 110-Small Fab - 1                  | D4635-4        | 1        | 3         | 0         |
|                                    | D4669-1        | 1        | 21        | 0         |
|                                    | D4695-4        | 1        | 3         | 0         |
|                                    | D4732-11       | 1        | 14        | 0         |
|                                    | D4732-39       | 1        | 12        | 0         |
|                                    | D4732-41       | 1        | 14        | 0         |
|                                    | D5022-5        | 1        | 4         | 0         |
| Part Specifications                |                |          |           |           |
| Specifications could not be found. |                |          |           |           |

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Date:

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



|                                  |             |                              |                                 |                                                                                                                                          |                   |                  |  |                  |  |
|----------------------------------|-------------|------------------------------|---------------------------------|------------------------------------------------------------------------------------------------------------------------------------------|-------------------|------------------|--|------------------|--|
| Job: _____                       |             | <b>DISPOSITION</b>           |                                 | <b>DEPARTMENT/PROCESS</b>                                                                                                                |                   |                  |  |                  |  |
| Part No. _____                   |             | Rework<br>Scrap<br>Use-as-is |                                 | Cross tube    Skid-tube    Eng. (Non-AW)<br>Small Fab    Machining    Prod. Eng. Coord.<br>Finishing    Large Fab    Rec/Store/Packaging |                   |                  |  |                  |  |
| Date :                           | Sequence #: | QTY Affected :               |                                 | MRB (QS042)                                                                                                                              |                   |                  |  |                  |  |
| Description Work Order Deviation |             |                              |                                 | Disposition                                                                                                                              |                   |                  |  |                  |  |
|                                  |             |                              |                                 |                                                                                                                                          |                   |                  |  |                  |  |
|                                  |             |                              |                                 | Completed By                                                                                                                             |                   |                  |  |                  |  |
|                                  |             |                              |                                 | Lead hand / Supervisor                                                                                                                   |                   |                  |  |                  |  |
|                                  |             |                              |                                 | QC / QA Coordinator                                                                                                                      |                   |                  |  |                  |  |
| <b>Root Cause</b>                |             | <b>FAULT CATEGORY</b>        |                                 |                                                                                                                                          |                   |                  |  |                  |  |
| Operator                         |             | Pressure/Forced              |                                 | Contamination                                                                                                                            |                   | Power Loss/Surge |  | Positioned Wrong |  |
| Manufacturing Process            |             | Bending                      | Misaligned/off center           | Folio/Program                                                                                                                            | Outside Tolerance |                  |  |                  |  |
| Equip/Tooling                    |             | Crushing                     | BOM/Route                       | Grain Direction                                                                                                                          | Drawing           |                  |  |                  |  |
| Handling/Preservation            |             | Cracks                       | Broken/Damage/Defect            | Weld                                                                                                                                     | Finish            |                  |  |                  |  |
| Material                         |             | Crimp/Kink/Ripple/Wave/Twist | Incomplete/Unclear Instructions | Wrong Stock Pulled                                                                                                                       | Part Lost/Missing |                  |  |                  |  |
| Product Improvement              |             | Marks/Chatter                | Drill Holes                     | Out of Sequence                                                                                                                          | Misread           |                  |  |                  |  |
| Process Improvement              |             | Mislabeled                   | Fit/Function                    | Off-set/Set-up                                                                                                                           |                   |                  |  |                  |  |
| Human Factors                    |             | Other/Details:               |                                 |                                                                                                                                          |                   |                  |  |                  |  |